

Date: Tuesday, 10/03/2009 11:27:41 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE ASSEMBLY
Job Number : 46394
Estimate Number : 13488
P.O. Number :
This Issue : 10/03/2009 S.O. No. :
Prsht Rev. : NC Part Number : D3805041
First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3805 REV.A
Previous Run : 45478 Project Number : N/A
Material :
Due Date : 18/03/2009 Qty: 2 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A 08-07-21 new issue DD verified by:EC
Est Rev:B 09-03-04 rev.a as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D38051 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fwd Plate

batch: B46397

EL 9-3-12

2.0 D38061 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

batch: B46398

EL 9-3-12

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- on D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: M110036

2-weld D3806-1 to wearplate by positioning holes together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M106115

EL 9-3-12 X2

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

EL 09-03-16

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 11:27:41 AM
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Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46394

Part Number: D3805041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/03/16 @

6.0

POWDER COATING

POWDER COATING



M109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:55

OVEN TEMPERATURE:

320°

FINISH TIME:

9:25

UND/EX

(X2)
09/03/17

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Y J



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

(X2)

8.0

D38071

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Gasket

batch:

B46400

83 09/03/17

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Scuff surface with 160grit sand paper
1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg

BATCH:

M109410

FF 09-03-19

(2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/03/19 (X2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock Location: _____

W/O 46375A01

u

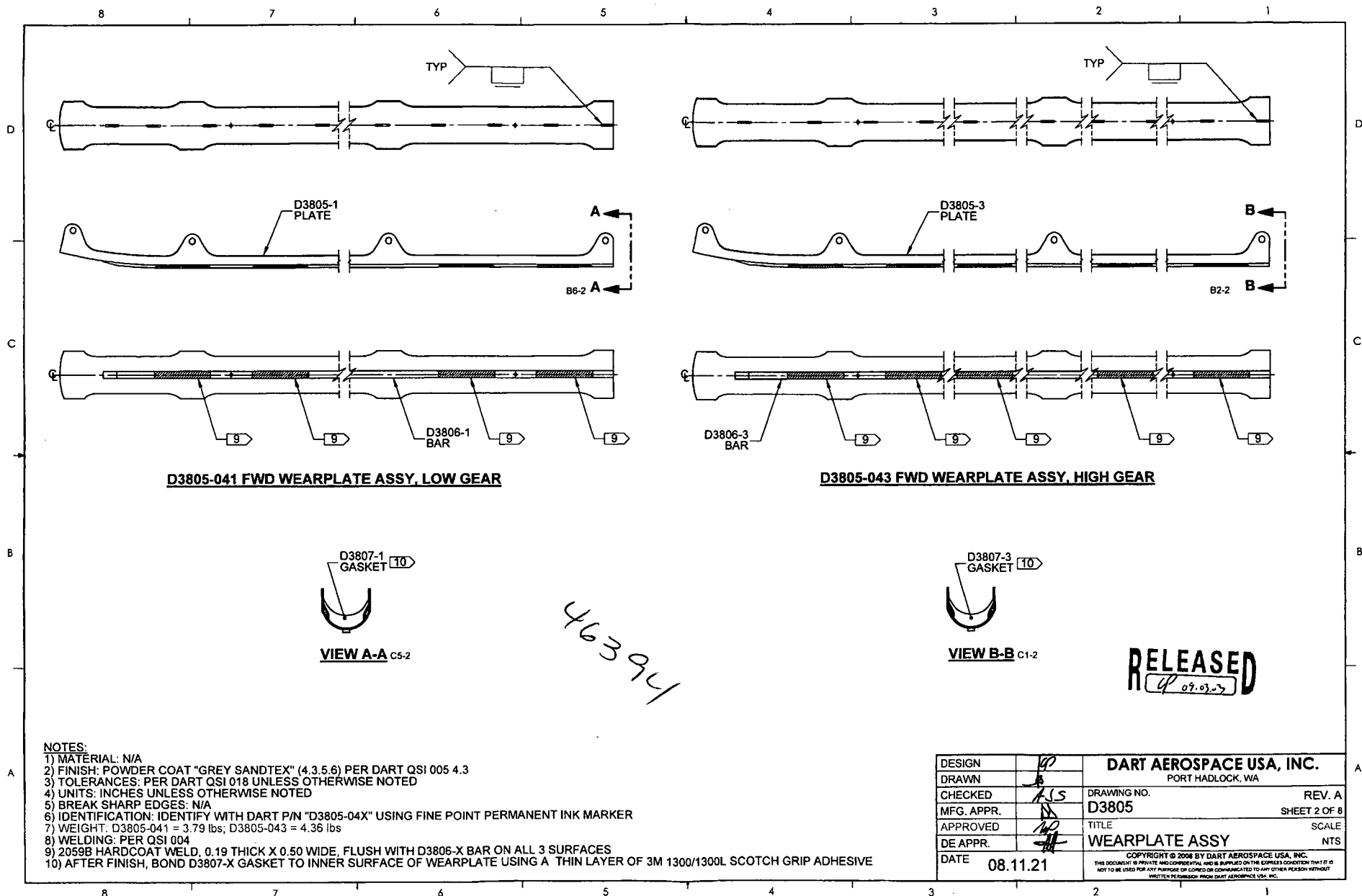
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NOTE: Date & initial all entries



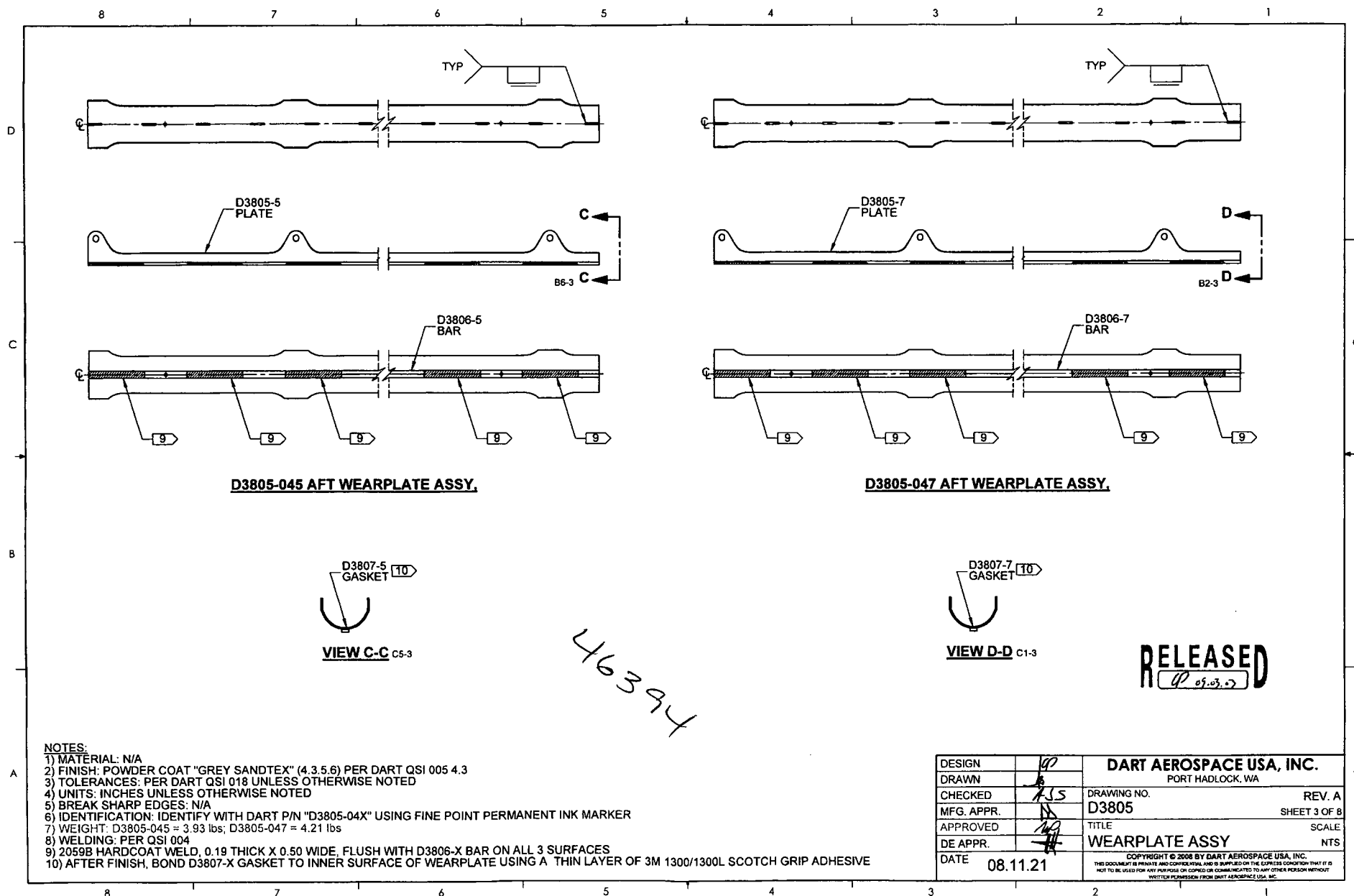
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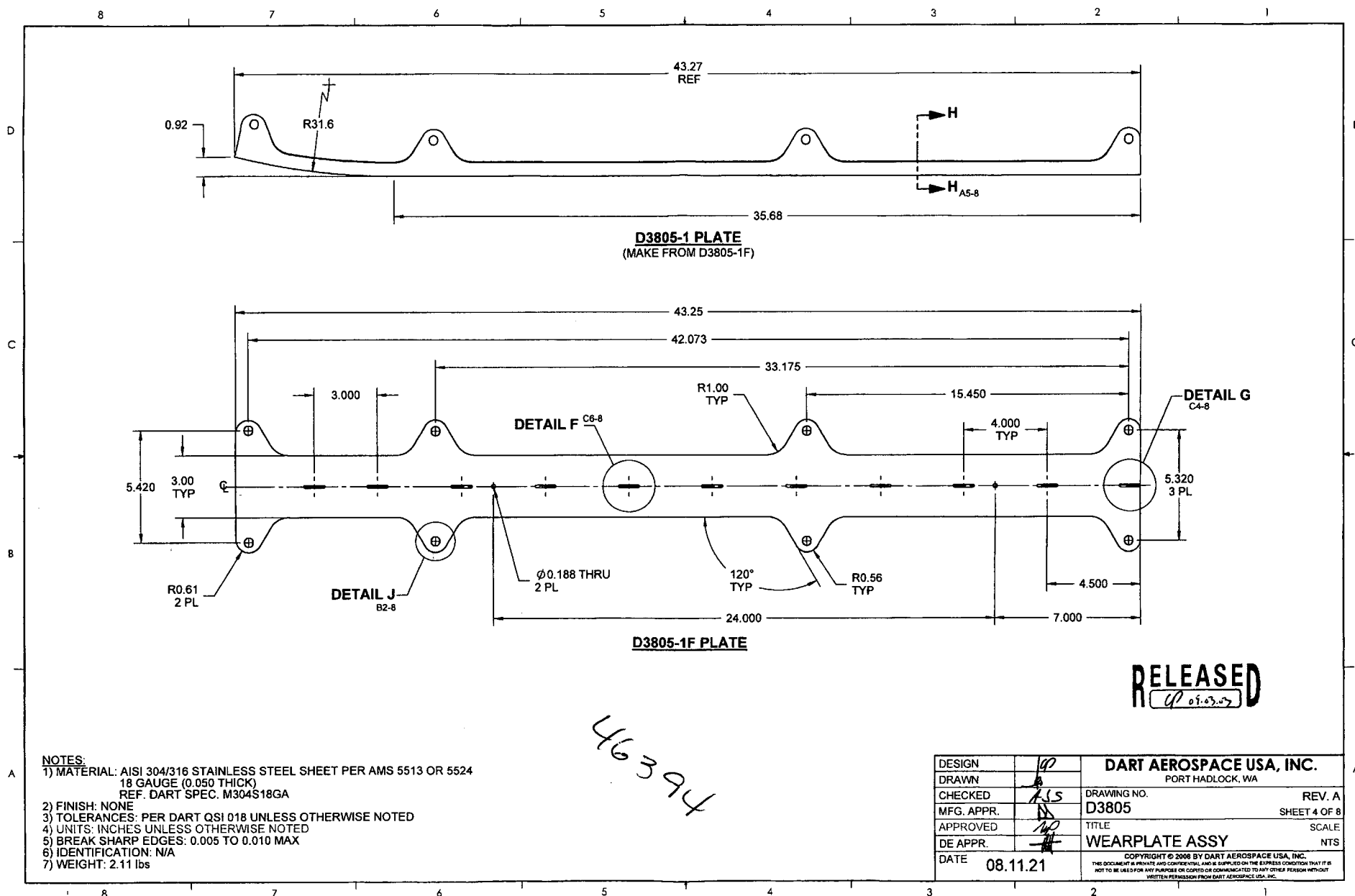
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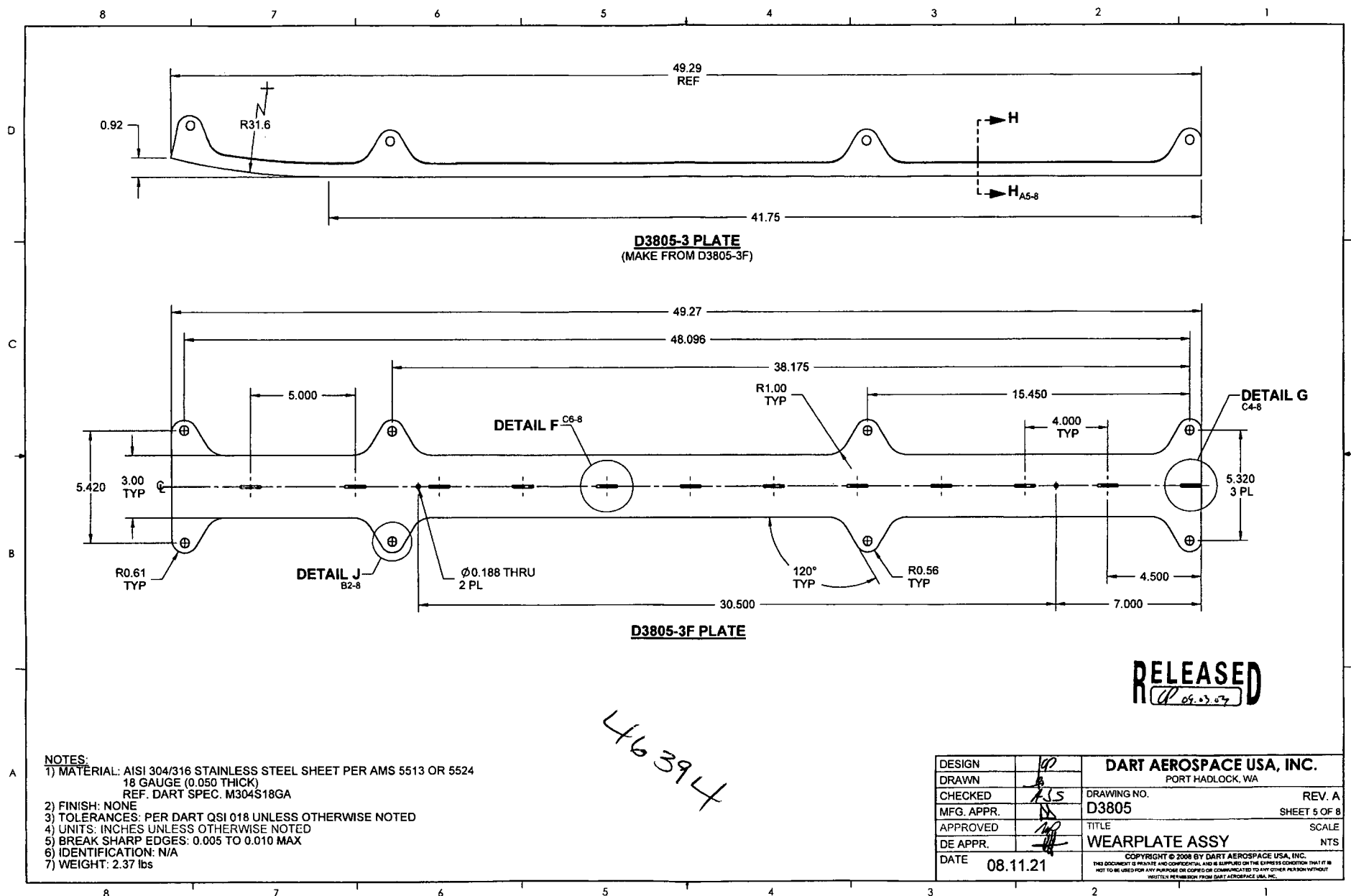
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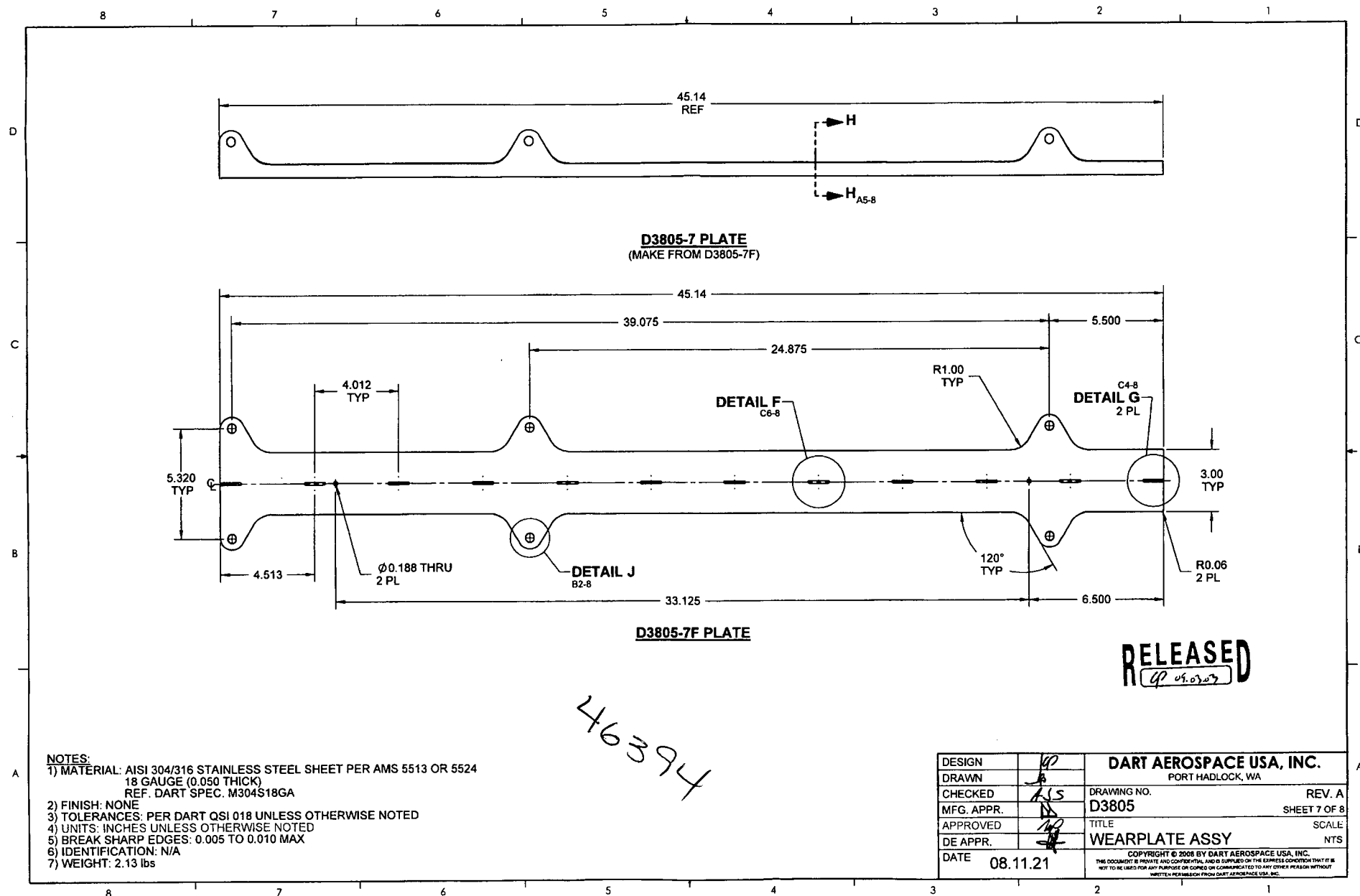
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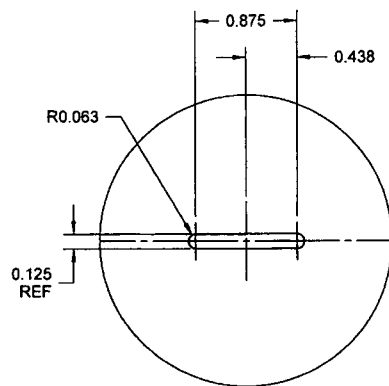
NOTE: Date & initial all entries



NOTES:

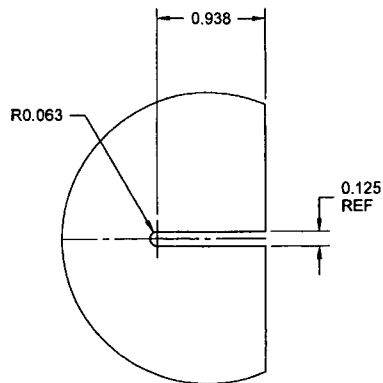
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	40	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3805	SHEET 7 OF 8
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DE APPR.	AS	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



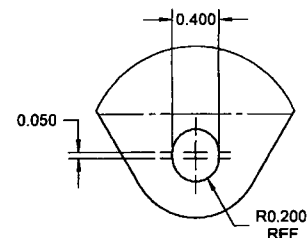
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SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



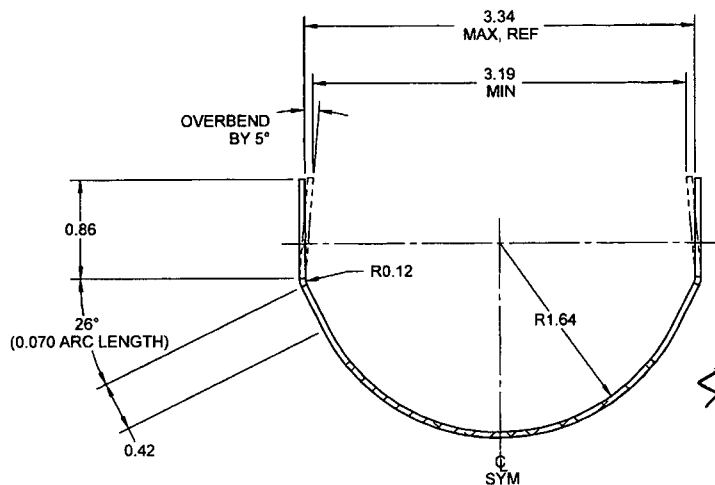
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B5-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

463 94

RELEASED
47 09 03 03

DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 8 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	WEARPLATE ASSY	NTS
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